

shp May 6

EUROCOPTER

# Work Order ID 67706



Page 1

Tuesday, March 29, 2011 1:06:43 PM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-03-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*[Handwritten notes: BG 11-5-5, 11 05 26 (5)]*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

*[Handwritten date: 11-04-28]*

*[Handwritten: 5, 0]*

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

D3272

A/R Aluminum Rod

*[Handwritten: M114703, M115928]*

3-Grind End Plate flush

**Work Order ID 67706**

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Tuesday, March 29, 2011 1:06:43 PM

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

5 0 BE 11/04/29

130 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

8 11/04/29

25 RM

140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

RE

5 0 A.E 11.04.29

**Work Order ID 67706**

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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

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Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 5.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

11-04-29

5

0



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

11-05-02

5

0

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 &amp; Dwg D3272

A/R Aluminum Rod 1114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

**Work Order ID 67706**

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Tuesday, March 29, 2011 1:06:43 PM

Item ID: D350-591-312

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Setup Start



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Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8/11/05/04

8/11/05/04

7m-1 11/05/04

XS  
RHSX  
RH

# Work Order ID 67706

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|                |                           |            |      |       |               |  |
|----------------|---------------------------|------------|------|-------|---------------|--|
| Item ID:       | D350-591-312              | Accept     |      | Setup | Start         |  |
| Revision ID:   |                           |            |      |       | Stop          |  |
| Item Name:     | Heli-Access-Step, Long RH |            |      |       |               |  |
| Start Date:    | 3/29/2011                 | Start Qty: | 5.00 |       | Cust Item ID: |  |
| Required Date: | 5/6/2011                  | Req'd Qty: | 5.00 |       | Customer:     |  |

## Reference:

|            |               |       |            |       |     |       |  |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run | Start |  |
|            | QC:           | Date: | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID          | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool #   | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 220<br><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br><br>Memo<br>START TIME: 11:00<br>OVEN TEMPERATURE: 320 °F<br>FINISH TIME: 11:30 | 0.00<br>0.00         |         |          |              | 5X RH         |               |                  |                |
|   |   |                      | M-L     | 11/05/05 |              |               |               |                  |                |
| 230<br><br>HandFinish<br>Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch M117315<br><br>Memo   | 0.00<br>0.00         |         |          |              |               |               |                  |                |
|   |   |                      |         |          |              |               |               |                  |                |
| 240<br><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo  | 0.00<br>0.00         |         |          |              |               |               |                  |                |
|   |   |                      |         |          |              |               |               |                  |                |

15 RH 11/05/05

11 05 05 (5)

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Item ID: D350-591-312

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Setup Start



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Start Date: 3/29/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/5/11 SL SD

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

11/05/06 (S)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312  
Location: \_\_\_\_\_

Rec B

11/5/11 SL SD

**Work Order ID 67706**

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/9-18

ME

11-05-09

# Picklist Print

Tuesday, March 29, 2011 1:06:49 PM

Page 1

Work Order ID: 67706

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF ☐  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D  
 fixe route seq in bom DD 10.04.28 verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3272-1<br>                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 0.0000          | 1           | 5            |               |                |        |
| Step                            |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
| D3067-1<br>                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 69.0000         | 1           | 5            |               |                |        |
| End Plate                       |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA016               | 867582           | 69              |                    |                 |             | 5            |               |                |        |
|                                 |                        |               |             |                     | 65969            | 69              |                    |                 |             |              |               |                |        |
| D3219-1<br>                     |                        | Manufactured  | No          |                     |                  | 110             | Each               | 56.0000         | 2           | 10           |               |                |        |
| Plate                           |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA017               | 867580           | 56              |                    |                 |             | 4            |               |                |        |
|                                 |                        |               |             |                     | 66133            | 56              |                    |                 |             | 6            |               |                |        |
| D3066-1<br>                     |                        | Manufactured  | No          |                     |                  | 180             | Each               | 53.0000         | 2           | 10           |               |                |        |
| Spacer                          |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | WA015               | 868337           | 53              |                    |                 |             | 10           |               |                |        |
|                                 |                        |               |             |                     | 66131            | 53              |                    |                 |             |              |               |                |        |

11.04.25 867708 (5)

11.04.28

5

11.04.29

4  
6

11.04.29

10



# Picklist Print

Tuesday, March 29, 2011 1:06:49 PM

Page 2

Work Order ID: 67706

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

1,600.000

16

80



Rivets



11-04-29

Location

Loc Qty

Loc Code

ST321

1500

116188

1500

80

WA018

100

116712

100

D3065-041

Manufactured

No

180

Each

47.0000

1

5



Step Leg Assembly Hi



11-04-29

Location

Loc Qty

Loc Code

WA014

367503

47

66149

27

66808

20

5

D3067-1

Manufactured

No

180

Each

69.0000

1

5



End Plate



11-04-29

Location

Loc Qty

Loc Code

WA016

367582

69

65969

69

5

AN3-35A

Purchased

No

250

Each

75.0000

2

10



Bolt



1117313 11/5/58 50

Location

Loc Qty

Loc Code

ST353

75

116191

75

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Shop Packet Print

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# Picklist Print

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Work Order ID: 67706

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

D3235-1 Manufactured No

250 Each

67.0000

2

10



Mounting Lug

Location

Loc Qty

Loc Code

ST471

67

65073

7

66941

60



SP

67831

D3278-041 Manufactured No

250 Each

55.0000

1

5



Support Assembly

Location

Loc Qty

Loc Code

ST471

55

66155

15

66946

40



B67584

AN960JD416 NAS1149D0463J Purchased No

250 Each

0.0000

16

80



Washer



M117291

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

4

20



Washer



M117291

AN5-36A Purchased No

250 Each

97.0000

2

10



Bolt



M117366

Location

Loc Qty

Loc Code

ST341

97

116704

97

# Picklist Print

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Work Order ID: 67706

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

D2618  
Bushing

Manufactured No

250 Each

94.0000

2

10

Location

Loc Qty

Loc Code

ST019

94

66942

94

Manufactured No

250 Each

27.0000

4

20

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST470

27

66936

27

Manufactured No

250 f

25.5200

1.2

6

D2856-400  
Abraison Strip

Location

Loc Qty

Loc Code

ST409

25.52

63735

25.52

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

2,189.000

2

10

Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

# Picklist Print

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Work Order ID: 67706

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/29/2011

Required Date: 5/6/2011

Start Qty: 5.00

Required Qty: 5.00

AN4-13A

Purchased

No

250

Each

336.0000

8

40



Bolt

Location

Loc Qty

Loc Code

ST357

336

116786

36

117094

300

Purchased

No

250

Each

941.0000

2

10

MS21042L5



Nut

Location

Loc Qty

Loc Code

ST300

941

115594

181

116105

500

116548

260

Purchased

No

250

Each

3,324.0000

8

40

MS21042L4



Nut

Location

Loc Qty

Loc Code

ST300

3324

116188

1324

116823

2000

Purchased

No

250

Each

0.0000

4

20

AN960JD10

NAS1149D0363J



Washer

31X  
M117313 SP M117628  
11/5/16

10  
40  
40  
M116583 11/5/16

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Shop Packet Print

Page 5

**DART**

|                      |                                |  |                        |
|----------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>90</i>  | DRAWN BY<br><i>[Signature]</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3272                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18     |                                | TITLE<br>STEP ASSEMBLY, HI LONG                          | SCALE<br>NTS           |
| A                    | 04.03.01                       | NEW ISSUE  |                        |
| B                    | 07.05.18                       | D3272-1 WAS D2622-120                                    |                        |

**RELEASED**07.06.04 *[Signature]*

| QTY<br>-041 | QTY<br>-042 | PART NUMBER  | DESCRIPTION                   |
|-------------|-------------|--------------|-------------------------------|
| X           |             | D3272-041    | STEP ASSEMBLY, HIGH LONG (LH) |
|             | X           | D3272-042    | STEP ASSEMBLY, HIGH LONG (RH) |
|             |             |              |                               |
| 1           | 1           | D3065-041    | LEG ASSEMBLY                  |
| 2           | 2           | D3066-1      | SPACER                        |
| 2           | 2           | D3067-1      | END PLATE                     |
| 2           | 2           | D3219-1      | SUPPORT                       |
| 1           | 1           | D3272-1      | STEP                          |
|             |             |              |                               |
| 16          | 16          | MS20600AD4W4 | RIVET                         |
|             |             |              |                               |

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

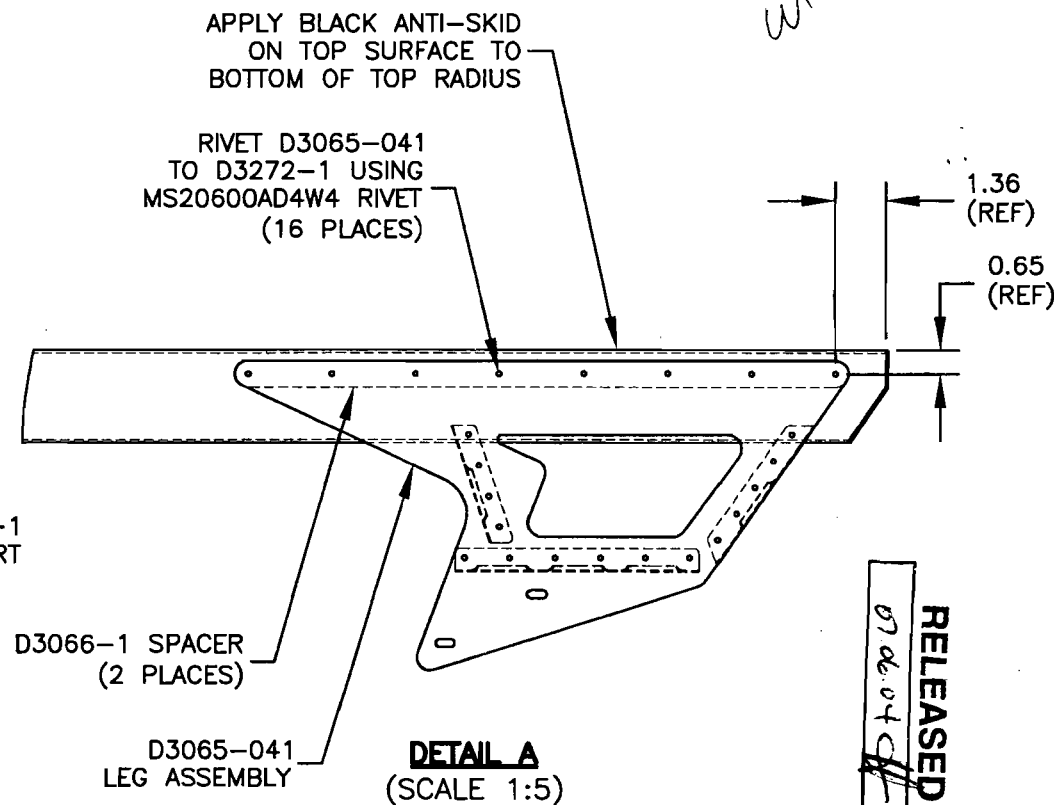
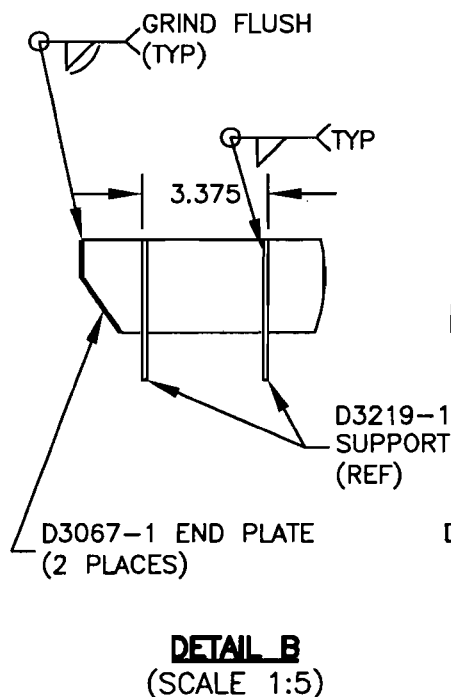
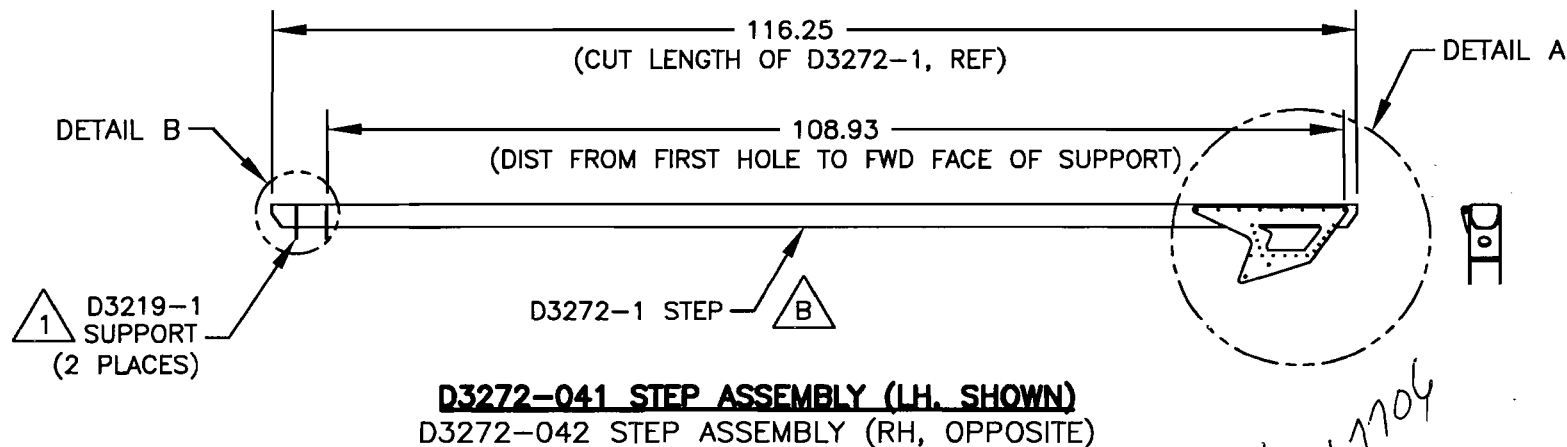
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NO. *62786*

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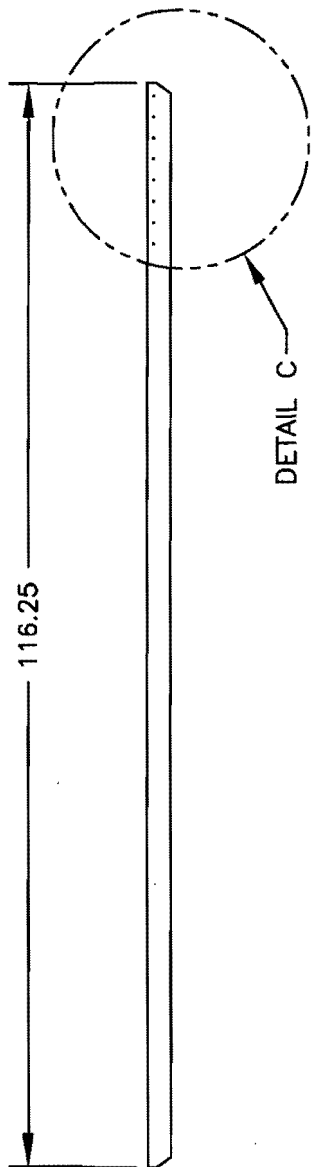


| DESIGN           | DRAWN BY                        | DART AEROSPACE LTD          |
|------------------|---------------------------------|-----------------------------|
| 99               | AS                              | HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>CE    | APPROVED<br>[Signature]         | DRAWING NO.<br>D3272        |
| DATE<br>07.05.18 | TITLE<br>STEP ASSEMBLY, HI LONG | REV. B<br>SHEET 2 OF 3      |
|                  |                                 | SCALE<br>1:20               |



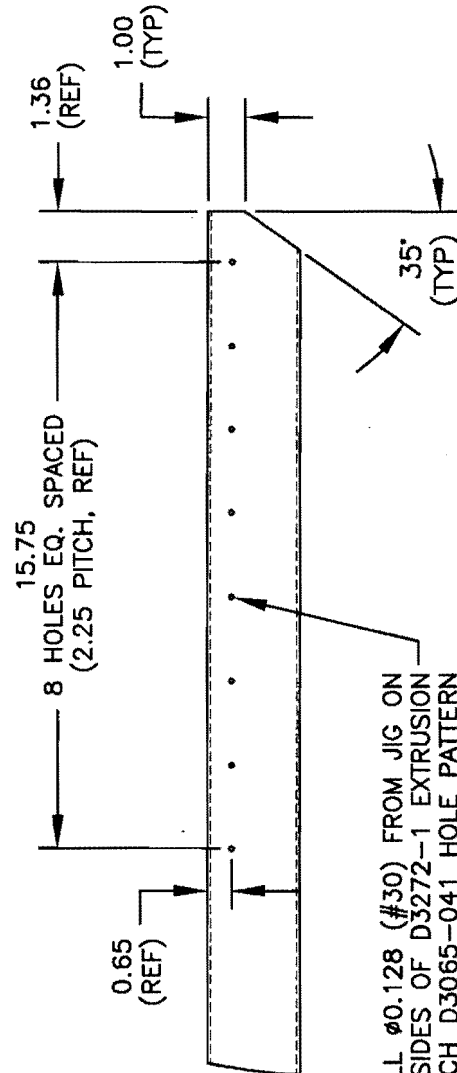


|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>GP</i>  | DRAWN BY<br><i>JB</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3272                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>07.05.18     |                                | TITLE<br>STEP ASSEMBLY, HI LONG                   | SCALE<br>1:20          |



**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

*2/6/2018*



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED  
07.06.04 *[Signature]*